

Work Order ID 109327

\*109327\*

Page 1

November-19-13 10:13:48 AM

Item ID: D2654-7

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Web

Start Date: 11/19/13 Start Qty: 1.00

Required Date: 12/03/13 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MLSDate: 13-11-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

F

100

0.00

\*100\*

Skidtubes

0.00

Skidtubes

Memo

1-Cut D2600-7 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

110

0.00

\*110\*

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

120

0.00

\*120\*

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

DC 13/11/20

3 13-11-20 JGL

13-11-25

Work Order ID 109327

\*109327\*

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November-19-13 10:13:48 AM

Item ID: D2654-7 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Web  
 Start Date: 11/19/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 12/03/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>L/E</u>  Memo	0.00  0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							



DP 13-11-25

DC 13/11/25

13/11/27

mf  
13-11-25

# Picklist Print

November-19-13 10:13:52 AM

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Work Order ID: 109327

\*109327\*

Parent Item: D2654-7

\*D2654-7\*

Parent Item Name: Web

Start Date: 11/19/13

Required Date: 12/03/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM  
IPP Rev:e 06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-7-140

Manufactured

No

100

Each

56.0000

1

\*D2600-7-140\*

\*\*

EXT "I BEAM" THICK

③  
ND 13-11-20

Location

Loc Qty

Loc Code

HALL

56

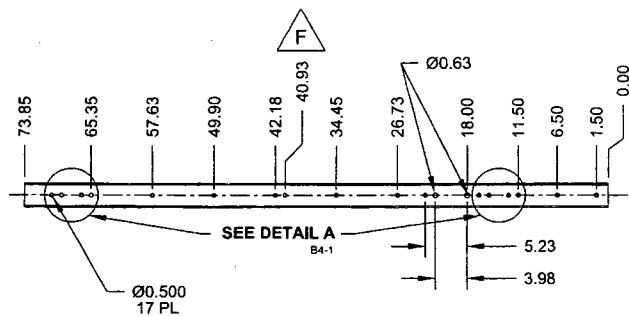
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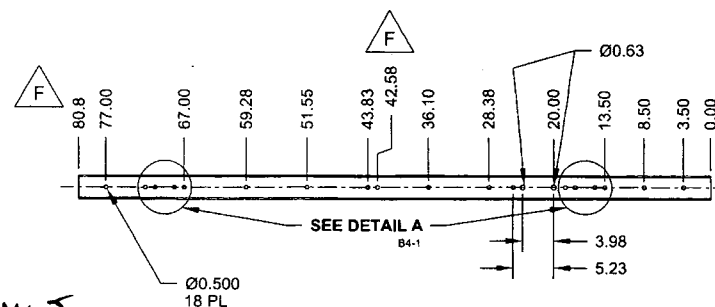
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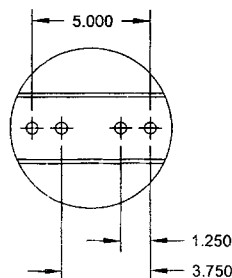
3



**D2654-1 WEB**



**D2654-3 WEB**



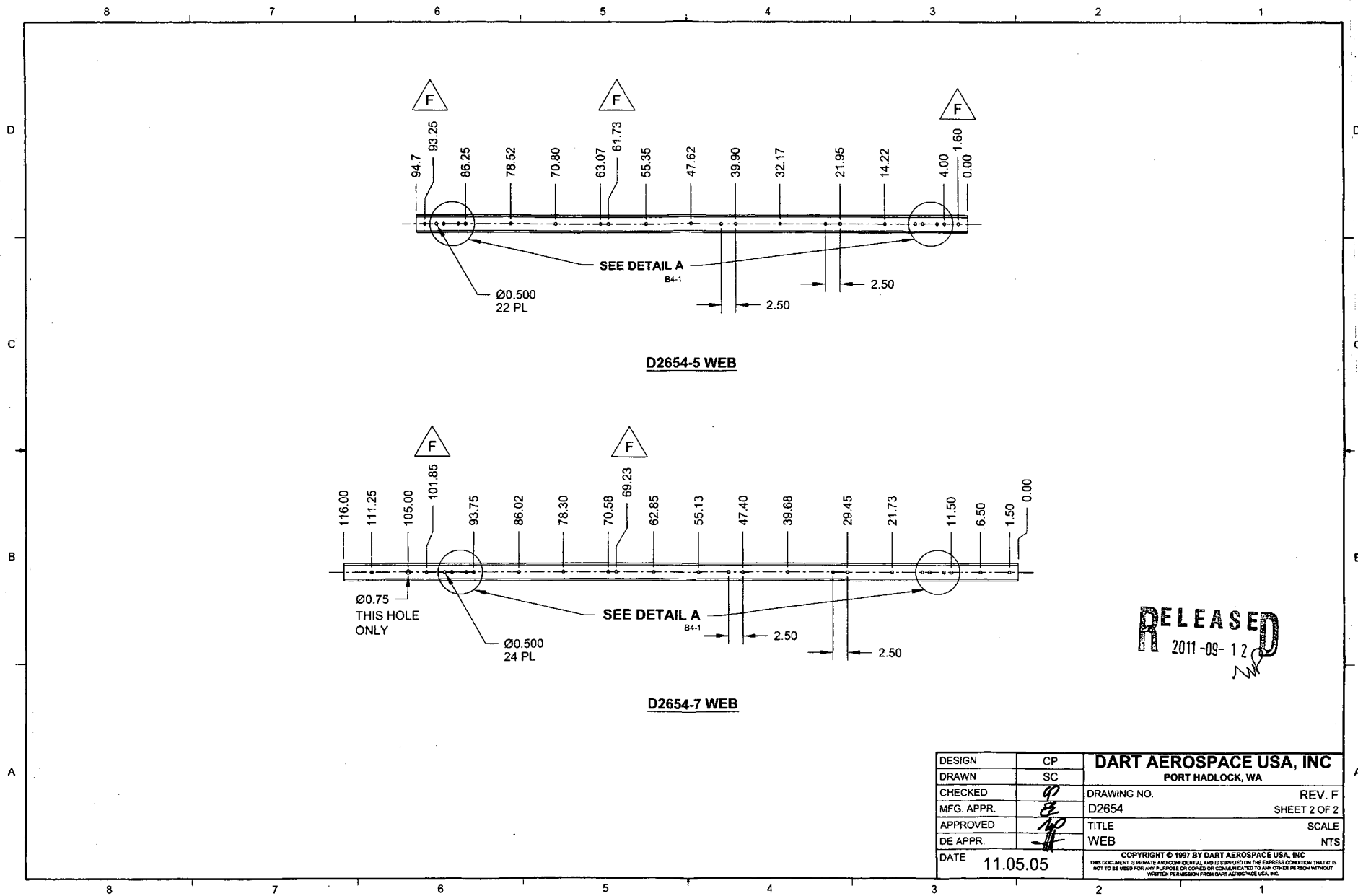
**DETAIL A**

**NOTES:**

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

**RELEASED**  
2011-09-12

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	W	DRAWING NO.	REV. F
MFG. APPR.	E	D2654	SHEET 1 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	WEB	NTS
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RELEASED  
2011-09-12  
JW

DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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